

Work Order ID 95646

January-16-13 8:34:10 AM

95646

Page 1

Item ID: D4005-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rear Restraint Angle Gutter

Stop

NS2

Start Date: 1/16/13 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/30/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: ML5Date: 13-01-16 Tooling:

Run Start

NR1

QC:

Date: SPC (Y/N):

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100 Waterjet									

Memo

0.00

8 0 Jm13-2-8

FLOW CNC Waterjet
2024.0631-Cut as per Dwg
Dwg Rev: B
Prog Rev: B

2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110
QC

0.00

8 0 Jm13-2-8

Quality Control

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other							

Work Order ID 95646

January-16-13 8:34:10 AM

95646

Page 2

Item ID: D4005-1

Accept

N900040100

Setup

Start ***NS1***

Revision ID:

Item Name: Rear Restraint Angle Gutter

Stop

NS2

Start Date: 1/16/13 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/30/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	AS 15 3-89	13.28		8			
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00							PTO SD 13/02/13
135 *135* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	AS 15 3-89	13.28		6	0		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *fwl* □

- Date

13/02/25

QA Closed: ✓ Date: 11/11/11

Date: (

Work Order: <u>A 95646</u> Part No. <u>D 4005 - 1</u> NCR No. <u>13-2351</u>				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				<input checked="" type="checkbox"/> Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update	<input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab	<input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab. <input type="checkbox"/> Finishing <input type="checkbox"/> Composite	<input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier	<input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data					2 piece crack when forming because pass on debur machine opposite way of grain direction		(DAS 16-9-09)	Scrap - destroy No replace	SB 13/02/13	DAS 15-9-09 13.2.13	(DAS 16-9-09) Q>2042 13/02/13
Equip/Tooling											
Operator	X										
Material	X										
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio				Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions			
								Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge			
								Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled			
								<input type="checkbox"/> Other			
Initiator Jet operate in form on A NOT passing through Deburr machine but in Deburr by hand											

• Work Order ID 95646

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95646

Page 3

Item ID: D4005-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rear Restraint Angle Gutter

Stop

NS2

Start Date: 1/16/13 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/30/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID
140

Operation
Description

Set Up/
Run Hours
0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

HandFinish

Hand Finishing

Memo

0.00

6 NG 13-219

145

QC7-Inspect Chemical Conversion Coat

0.00

145

QC

Quality Control

Memo

0.00

6 φ 13-219

150

Gloss Grey (4.3.5.15) per QSI 005 4.3

0.00

150

Powdercoat

Powder Coating

Memo

0.00

Start Time: 10:00
Oven Temperature: 320°
Finish Time: 10:30

6 φ B13-219

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS				
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other		
Part No. _____									
NCR No. _____									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									
FAULT CATEGORY									
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions					
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other					
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled					

Work Order ID 95646

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95646

Page 4

Item ID: D4005-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rear Restraint Angle Gutter

Stop

NS2

Start Date: 1/16/13 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/30/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00	Smf	13-02-19		6			
164 *164* Small Fab Small Fab	Memo	0.00				6			FF 13-02-19
166 *166* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Smf	13-02-19		6			

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other							
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							

Work Order ID 95646

January-16-13 8:34:10 AM

95646

Page 5

Item ID: D4005-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rear Restraint Angle Gutter

Stop

NS2

Start Date: 1/16/13 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/30/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID

170

Operation
Description

Identify as per dwg & Stock Location: ST 243

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp***170***

Packaging

Packaging

Memo

0.00

6x

Sp

13-2-20

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Quality Control

Memo

0.00

13/2/2020

MB 02/20

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear					General						
					Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube	Bend BOM/Route Broken/Damaged Burr Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio	Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabelled Misread Offset Out of Calibration Out of Sequence Outside Dimensions	Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	Other	

Picklist Print

January-16-13 8:34:15 AM

Page 1

Work Order ID: 95646

95646

Parent Item: D4005-1

D4005-1

Parent Item Name: Rear Restraint Angle Gutter

Start Date: 1/16/13

Required Date: 1/30/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A 10.01.21 new issue Prelim EC verified by:DD IPP Rev:B
 10.05.03 as per ECN10-562 DD verified by:EC IPP Rev:C 10.11.11
 added abrasion strip DD verified by:E IPP Rev:D 12.03.07 as per dwg rev.b
 DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	212.7400	0.1451	0.765684	6.85		

M2024T3S.063

2024-T3.063 sheet

Location	Loc Qty	Loc Code
MAT022	212.74	
119916	0.2	
121197	21.34	
123096	11.4	
123654	12.8	
123701	167	

D2856-100-1100

Manufactured No

D2856-100-1100

Abrasion Strip
cut one at 11.00"

90764 164 Each 0.0000

1 5 123307

6 8F 13-02-19

Q

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>			
Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>							
Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspector Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>							
Crushed/Crimped. <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>							
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>								
Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>								
Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>								
Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>	Other <input type="checkbox"/>								
Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>									
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>									
Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>									

DART AEROSPACE LTD	Work Order:	95646
Description: Rear Restraint Angle Gutter	Part Number:	D4005-1
Inspection Dwg: D4005	Rev: A	Page 1 of 1

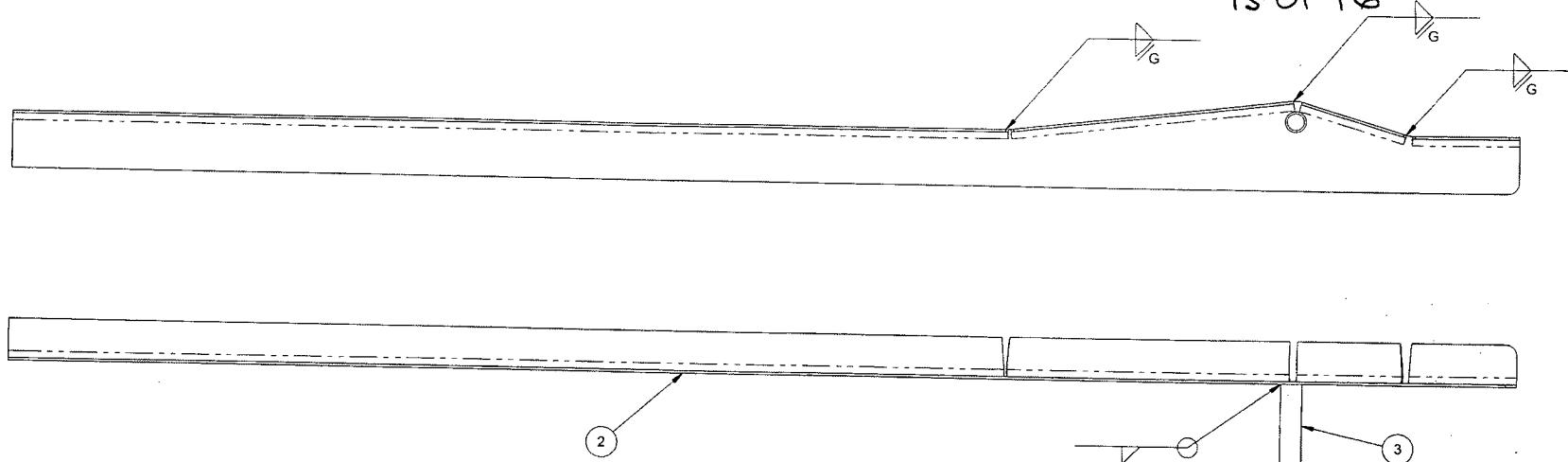
FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	JM	Audited by:	15 2-89	Preliminary Approval:	
Date:	13-2-8	Date:	13-2-8	Date:	

Rev	Date	Change	Revised by	Approved
A	11.06.21	New Issue	KJ	

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4005-041	FORWARD FLOOR GUTTER	JCA-M47-2-22
2	1	D4005-13	ANGLE	
3	1	D4003-13	TUBE	

SHOP
REF ID: 130116
ENGINEER
UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK OR
NO. 95646 MLJ
13-01-16



D4005-041 FORWARD FLOOR GUTTER

A NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.22 lbs
- 8) WELD PER DART QSI 004

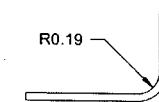
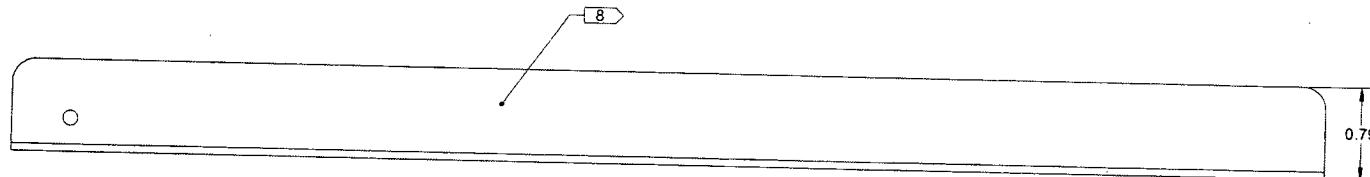
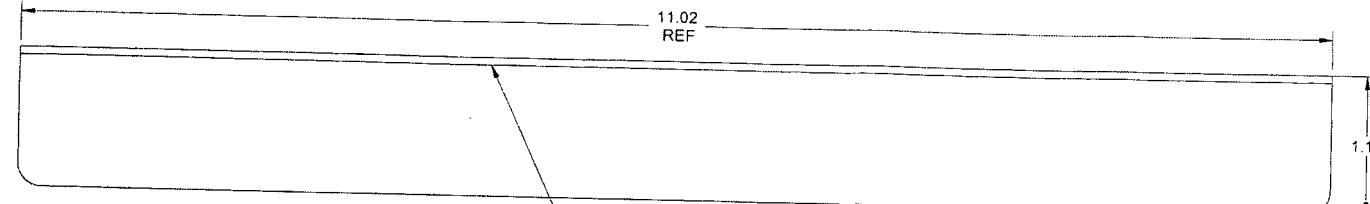
B	ADD TOOLING HOLE, ZN C7-3	65	11.06.06
A	NEW ISSUE	HS	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	BB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BB		
CHECKED	B		
MFG. APPR.	E		
APPROVED	M		
DE APPR.	H		
DATE	11.06.06	SCALE	NTS

RELEASER
R 2012-03-02
MP

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8 1 7 6 1 5 1 4 1 3 1 2 1 1

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-1	JCA-M47-2-03



D4005-1 REAR RESTRAINT ANGLE GUTTER

RELEASED
2012-03-02
N

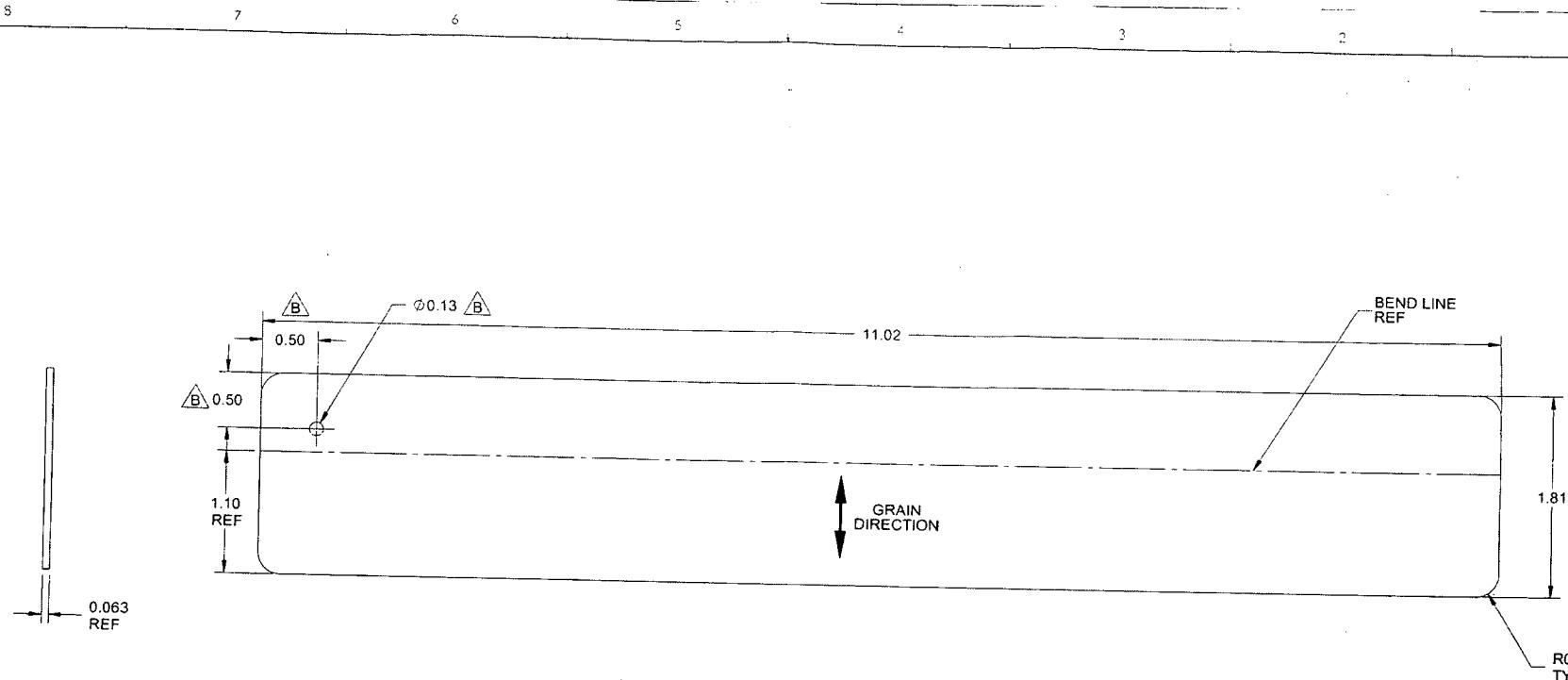
NOTES:

- 1) MATERIAL: MADE FROM D4005-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs
- 8) COVER THIS SURFACE WITH D2856-100-11 ABRASION STRIP. TRIM EXCESS

DESIGN	<i>BB</i>	DART AEROSPACE LTD
DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BB</i>	DRAWING NO.
MFG. APPR.	<i>BB</i>	REV. B
APPROVED	<i>BB</i>	D4005
DE APPR.	<i>BB</i>	SHEET 2 OF 15
DATE	11.06.06	TITLE
		SCALE
		NTS
		RESTRAINT

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95646



D4005-1F FLAT PATTERN

RELEASER
2012-03-07
NP

NOTES:

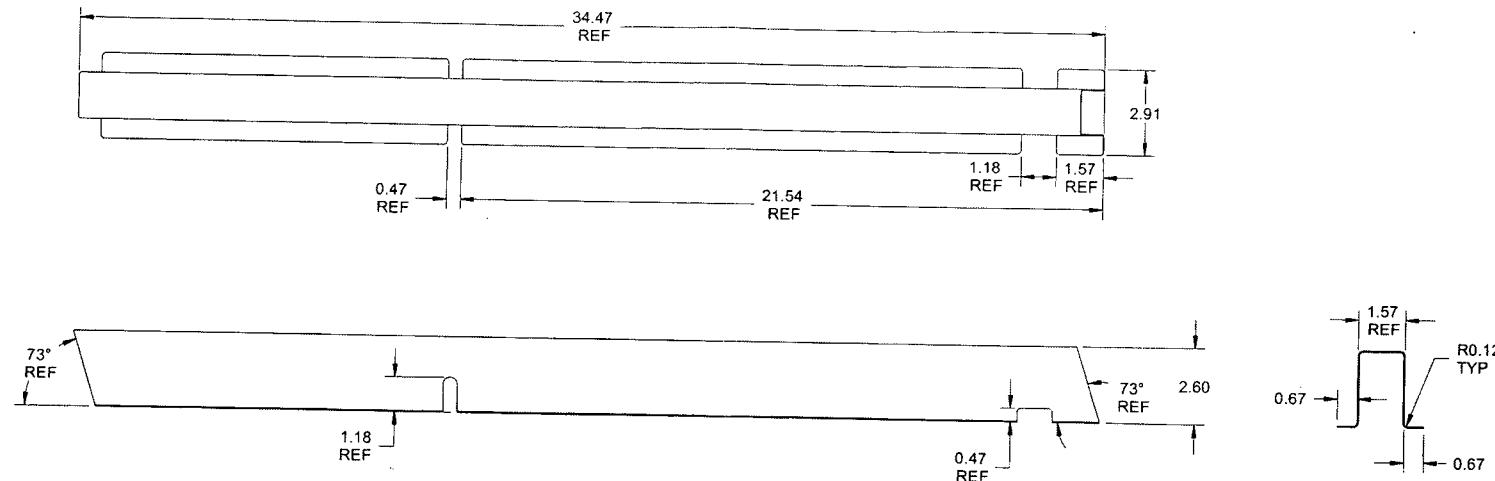
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN	AB	DART AEROSPACE LTD	
DRAWN	AB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BB	DRAWING NO.	
MFG. APPR.	EE	D4005	REV. B
APPROVED	AB	SHEET 3 OF 15	SCALE
DE APPR.	AB	NTS	NTS
DATE	11.06.06	RESTRAINT	

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8 7 6 5 4 3 2 1

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-3	JCA-M47-2-05



D4005-3 FORWARD RESTRAINT BEAM

RELEASED
2012-03-02
JND

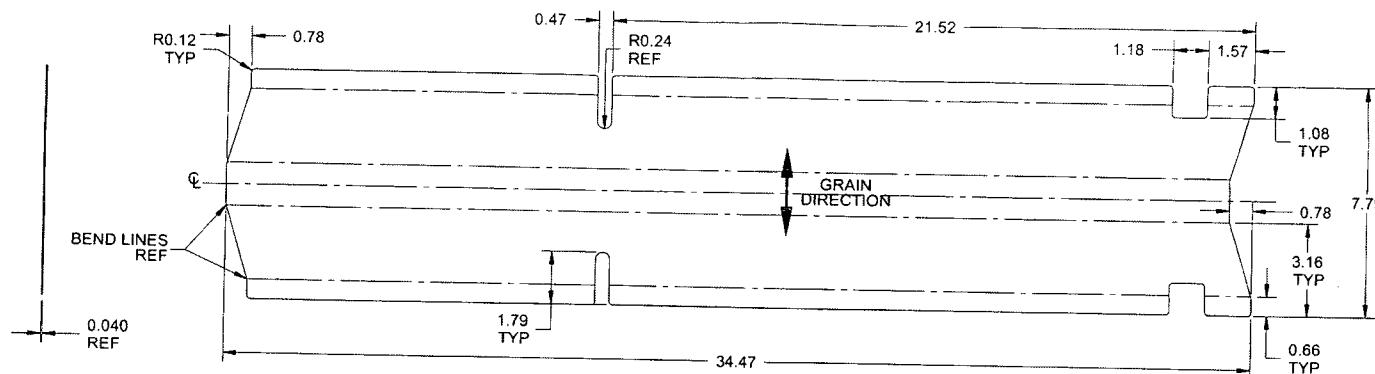
NOTES:

- 1) MATERIAL: MADE FROM D4005-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.01 lbs

DESIGN	851	DART AEROSPACE LTD
DRAWN	851	HAWKESBURY, ONTARIO, CANADA
CHECKED	13	
MFG. APPR.	PE	REV. B
APPROVED	149	SHEET 4 OF 15
DE APPR.	149	TITLE
DATE	11.06.06	SCALE
		RESTRAINT
		NTS

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D4005-3F FLAT PATTERN

NOTES:

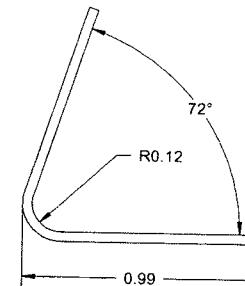
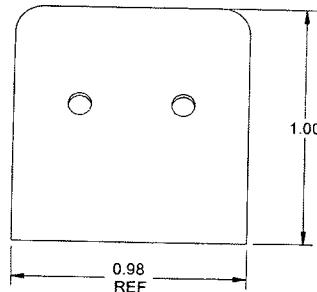
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.01 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>	DRAWING NO.
MFG. APPR.	<i>AS</i>	REV. B
APPROVED	<i>AS</i>	D4005
DE APPR.	<i>AS</i>	SHEET 5 OF 15
DATE	11.06.06	TITLE
		SCALE
		NTS
		RESTRAINT

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RELEASED
2012-03-03
AS

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-5	JCA-M47-2-06



D4005-5 ANGLE

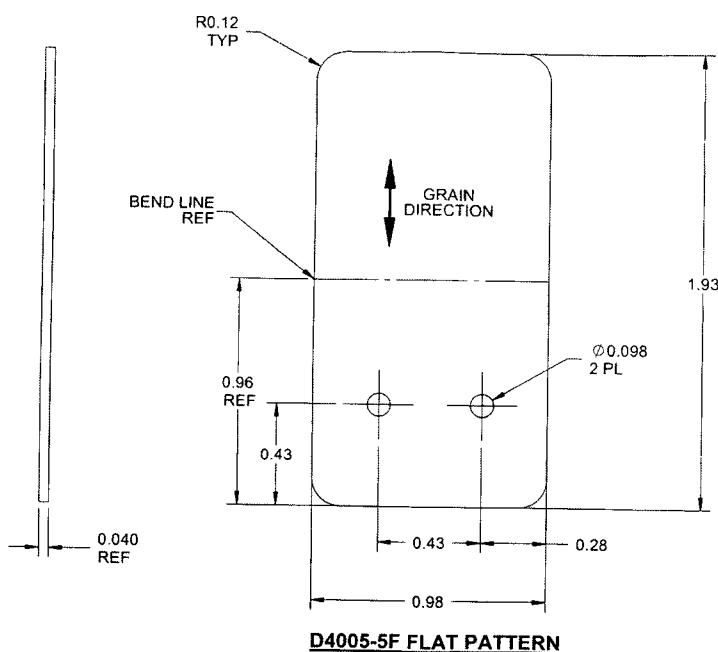
RELEASED
2012-03-02
NP

NOTES:

- 1) MATERIAL: MADE FROM D4005-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	DRAWING NO.
MFG. APPR.	<i>AB</i>	REV. B
APPROVED	<i>AB</i>	D4005
DE APPR.	<i>AB</i>	SHEET 6 OF 15
DATE	11.06.06	SCALE
		NTS

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NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	<i>1</i>	DART AEROSPACE LTD
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>1</i>	DRAWING NO. REV. B
MFG. APPR.	<i>1</i>	D4005 SHEET 7 OF 15
APPROVED	<i>1</i>	TITLE
DE APPR.	<i>1</i>	SCALE
DATE	11.06.06	NTS

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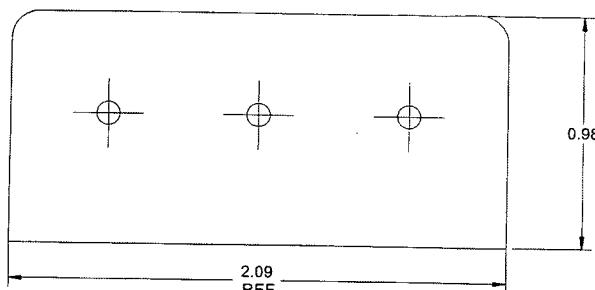
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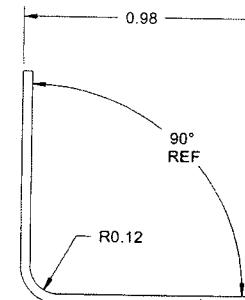
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DART AEROSPACE PART NUMBER D4005-7	JOHN CAMERON AVIATION PART NUMBER JCA-M47-2-07
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D4005-7 ANGLE



2012-03-02
AP

NOTES:

- 1) MATERIAL: MADE FROM D4005-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

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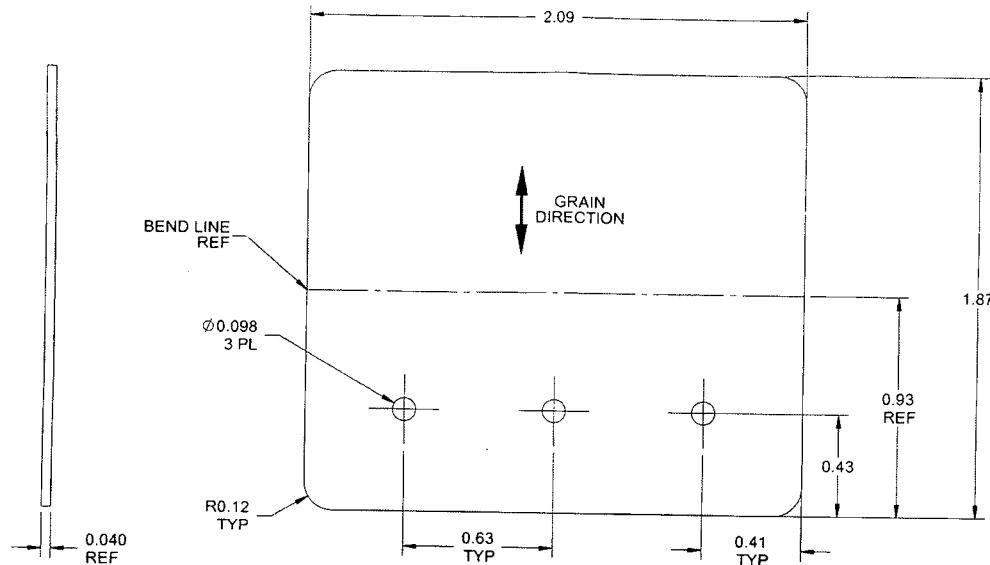
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1

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	DRAWING NO.
MFG. APPR.	<i>AB</i>	REV. B
APPROVED	<i>AB</i>	D4005
DE APPR.	<i>AB</i>	SHEET 8 OF 15
DATE	11.06.06	TITLE
		RESTRAINT
		SCALE
		NTS

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D4005-7F FLAT PATTERN

RELEASED
2012-03-02
NP

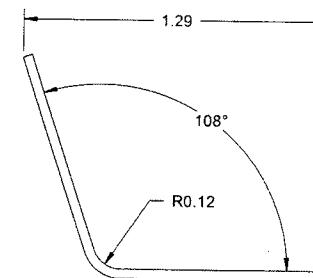
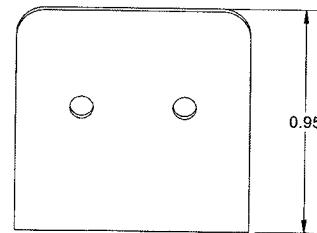
NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AB</i>	D4005	SHEET 9 OF 15
APPROVED	<i>AB</i>	TITLE	SCALE
DE APPR.	<i>AB</i>	RESTRAINT	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-9	JCA-M47-2-08

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D4005-9 ANGLE

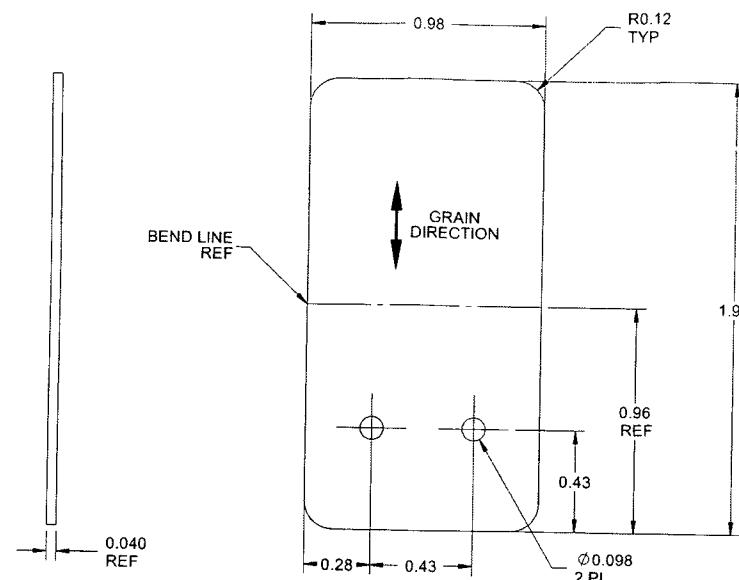
NOTES:

- 1) MATERIAL: MADE FROM D4005-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	<i>BS</i>	DART AEROSPACE LTD	
DRAWN	<i>BS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BS</i>	D4005	SHEET 10 OF 15
APPROVED	<i>BS</i>	TITLE	SCALE
DE APPR.	<i>BS</i>	RESTRAINT	NTS
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RELEASED
11 2012-03-02
JAP

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D4005-9F FLAT PATTERN

RELEASED
12 2012-03-02
MP

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	<i>BB</i>	DART AEROSPACE LTD	
DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED	<i>BB</i>	DRAWING NO.	
MFG. APPR.	<i>BB</i>	D4005	SHEET 11 OF 15
APPROVED	<i>BB</i>	TITLE	SCALE
DE APPR.	<i>BB</i>	RESTRAINT	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-11	JCA-M47-2-12

D

D

C

C

B

B

A

A

NOTES:

- 1) MATERIAL: MADE FROM D4005-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs

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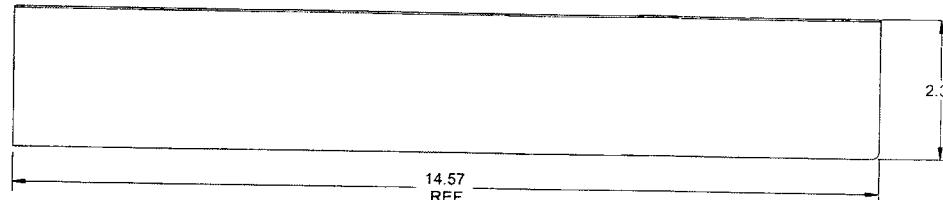
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4

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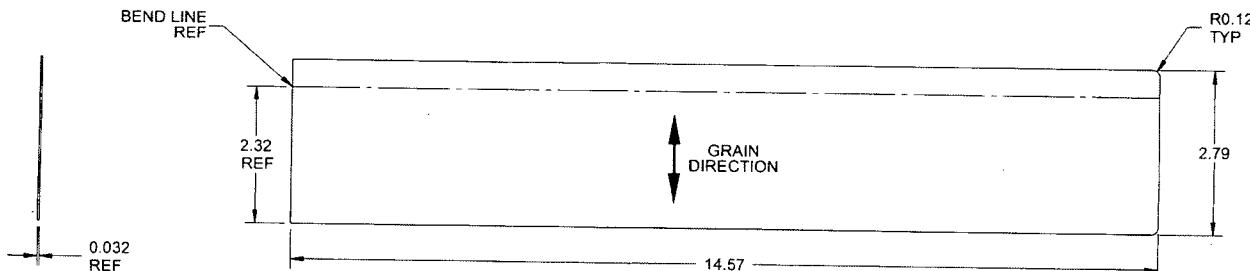
2

1

**D4005-11 FINISHING STRIP**

11.06.06
2012-03-02
JMK

DESIGN	<i>BS</i>	DART AEROSPACE LTD
DRAWN	<i>BS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BS</i>	DRAWING NO.
MFG. APPR.	<i>BS</i>	REV. B
APPROVED	<i>BS</i>	D4005 SHEET 12 OF 15
DE APPR.	<i>BS</i>	TITLE
		SCALE
		NTS
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D4005-11F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.032
- OR 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS -QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
- OR 5052-H32 ALUMINUM SHEET
PER QQ-A-250/8 OR AMS-QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	
MFG. APPR.	<i>EZ</i>	REV. B	
APPROVED	<i>AB</i>	D4005	
DE APPR.	<i>AB</i>	SHEET 13 OF 15	
TITLE		SCALE	NTS
RESTRAINT			
DATE 11.06.06		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

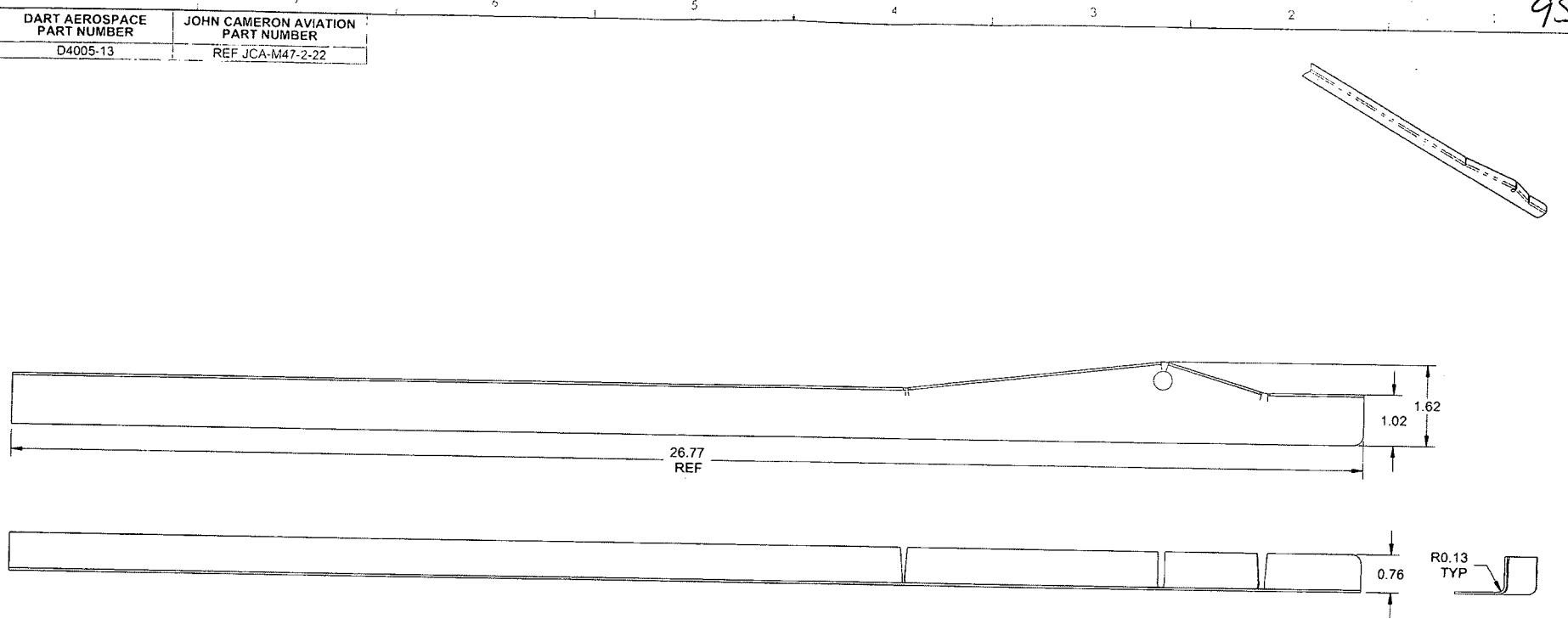
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2012-03-02
AB

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-13	REF JCA-M47-2-22



D4005-13 ANGLE

RELEASED
2012-03-07
JK

NOTES:

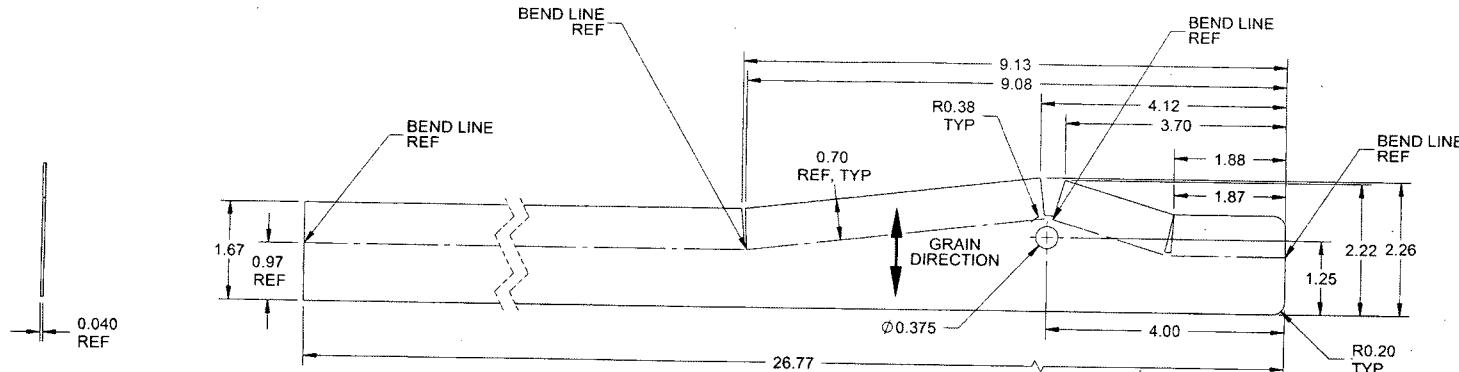
- 1) MATERIAL: MADE FROM D4005-13F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	DRAWING NO.
MFG. APPR.	<i>AB</i>	REV. B
APPROVED	<i>AB</i>	D4005
DE APPR.	<i>AB</i>	SHEET 14 OF 15
DATE	11.06.06	TITLE
		SCALE
		NTS

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8 1 7 1 6 1 5 1 4 1 3 1 2 1 1 1

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D4005-13F FLAT PATTERN

2012-03-02
M

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>	
MFG. APPR.	<i>AS</i>	REV. B
APPROVED	<i>AS</i>	DRAWING NO. D4005 SHEET 15 OF 15
DE APPR.	<i>AS</i>	TITLE RESTRAINT
DATE	11.06.06	SCALE NTS

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8 7 6 5 4 3 2 1